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# Operating Instructions and Parts Manual
# 14-inch Woodworking Band Saw
**Models: JWBS-14OS, JWBS-14CS**

c UL® Listed 80MJ

**WMH TOOL GROUP**

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This manual has been prepared for the owner and operators of a JET JWBS-14 Band Saw. Its purpose, aside from machine operation, is to promote safety using accepted operating and maintenance procedures. To obtain maximum life and efficiency from your band saw and to aid in using it safely, please read this manual thoroughly and follow the instructions carefully.

# Warranty and Service

WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can provide quick service or information.

In most cases, a WMH Tool Group Service Center can assist in authorizing repair work, obtaining parts, or perform routine or major maintenance repair on your JET product.

For the name of an Authorized Service Center in your area, please call 1-800-274-6848, or visit our web site at www.wmhtoolgroup.com

**More Information**

Remember, WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit our web site at www.wmhtoolgroup.com

**WMH Tool Group Warranty**

WMH Tool Group makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

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To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Service Center designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product at our discretion, or refund the purchase price if we cannot readily and quickly provide a repair or replacement. We will return the repaired product or replacement at WMH Tool Group's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of WMH Tool Group's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights, which vary from state to state.

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# Warnings

1. Read and understand the entire owners manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This band saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a band saw, do not use until proper training and knowledge have been obtained.
5. Do not use this band saw for other than its intended use. If used for other purposes, WMH Tool Group disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this band saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this band saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead based paint.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.

10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
16. Make sure the band saw is firmly secured to the floor or bench before use.
17. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.
20. Keep visitors a safe distance from the work area. **Keep children away.**

# Warnings

21. Make your workshop child proof with padlocks, master switches or by removing starter keys.
22. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep blade sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Make sure the work piece is held firmly against the rip fence or miter gauge as it is fed through the blade.
28. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.
30. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
31. Remove loose items and unnecessary work pieces from the area before starting the machine.

**Familiarize yourself with the following safety notices used in this manual:**

**⚠CAUTION** This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

**⚠WARNING** This means that if precautions are not heeded, it may result in serious injury or possibly even death.

## - - SAVE THESE INSTRUCTIONS - -

# Introduction

This manual is provided by JET covering the safe operation and maintenance procedures for a Model JWBS-14 Band Saw. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or WMH Tool Group. WMH Tool Group can also be reached at our web site: www.wmhtoolgroup.com.

# Specifications

| Model Number: | JWBS-14OS | JWBS-14CS |
|---|---|---|
| Stock Number | 708113 | 708115K |
| Cutting Capacity (height/in.) | 6 | 6 |
| Cutting Capacity (width/in.) | 13-1/2 | 13-1/2 |
| Minimum Blade Width (in.) | 1/8 | 1/8 |
| Maximum Blade Width (in.) | 3/4 | 3/4 |
| Blade Length (in.) | 93-1/2 | 93-1/2 |
| Blade Speed (SFPM) | 3000 | 3000 |
| Table Size (in.) | 15 x 15 | 15 x 15 |
| Table Slot Size (DxW/in.) | 3/8 x 3/4 | 3/8 x 3/4 |
| Table Height From Floor (in.) | 44 | 43-1/2 |
| Table Tilt (deg.) | 45 right, 10 left | 45 right, 10 left |
| Dust Port Diameter (in.) | 4 | 4 |
| Overall Dimensions (HxWxD/in.) | 68 x 34 x 20 | 68 x 26 x 19 |
| Motor | 3/4HP, 1Ph, 115/230V (prewired 115) | 1HP, 1Ph, 115/230V (prewired 115) |
| Net Weight (lbs.) | 172 | 185 |
| Shipping Weight (lbs.) | 183 | 197 |

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, WHM Tool Group reserves the right to change specifications at any time and without prior notice, without incurring obligations.

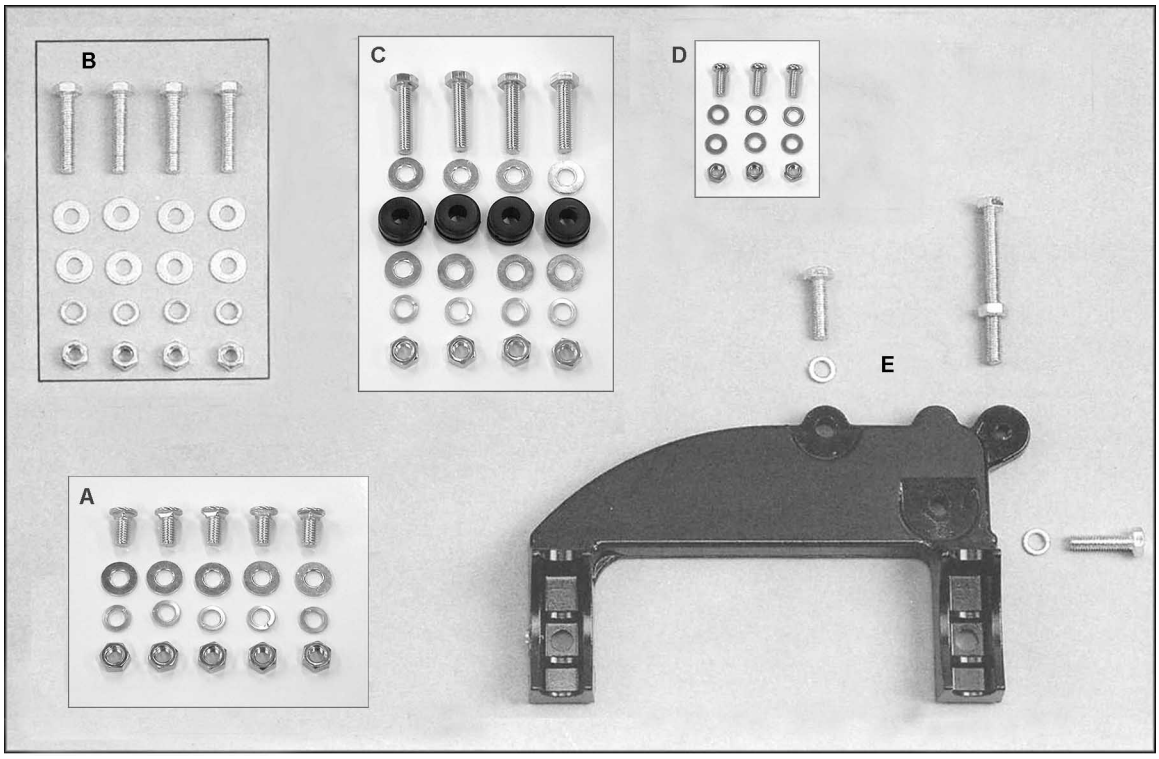
# Unpacking – JWBS-14OS

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

## Contents of the Shipping Container

1 Stand top with motor support plate
4 Stand legs
2 Cross braces-short
2 Cross braces-long
1 Stand support plate
1 Saw body
1 Table
1 Motor
1 V-belt
1 Pulley cover
2 Table lock knobs
1 Table pin
1 Trunnion support bracket
1 Fastener package (see below)
1 Instruction Manual
1 Warranty Card

## Fasteners




**A. Stand Assembly** (partial quantity shown)
40 – M8x16 carriage bolts
40 – M8 flat washers
40 – M8 lock washers
40 – M8 hex nuts

**B. Saw Body to Stand**
4 – M8x40 hex cap screws (approx. 1-1/2")
8 – M8 flat washers
4 – M8 lock washers
4 – M8 hex nuts

**C. Motor to Stand**
4 – M8x35 hex cap screws (approx. 1-3/8")
8 – M8 flat washers
4 – rubber grommets
4 – M8 lock washers
4 – M8 hex nuts

**D. Pulley Cover to Stand**
3 – M5x12 pan head screws (approx. 1/2")
6 – M5 flat washers
3 – M5 hex nuts

**E. Trunnion Support Bracket to Saw Body**
2 – M8x30 hex cap screws (approx. 1-1/4")
2 – M8 lock washers
1 – M8x80 hex cap screw (for table stop - approx. 3-1/8" long)
1 – M8 hex nut (for table stop)

# Unpacking – JWBS-14CS

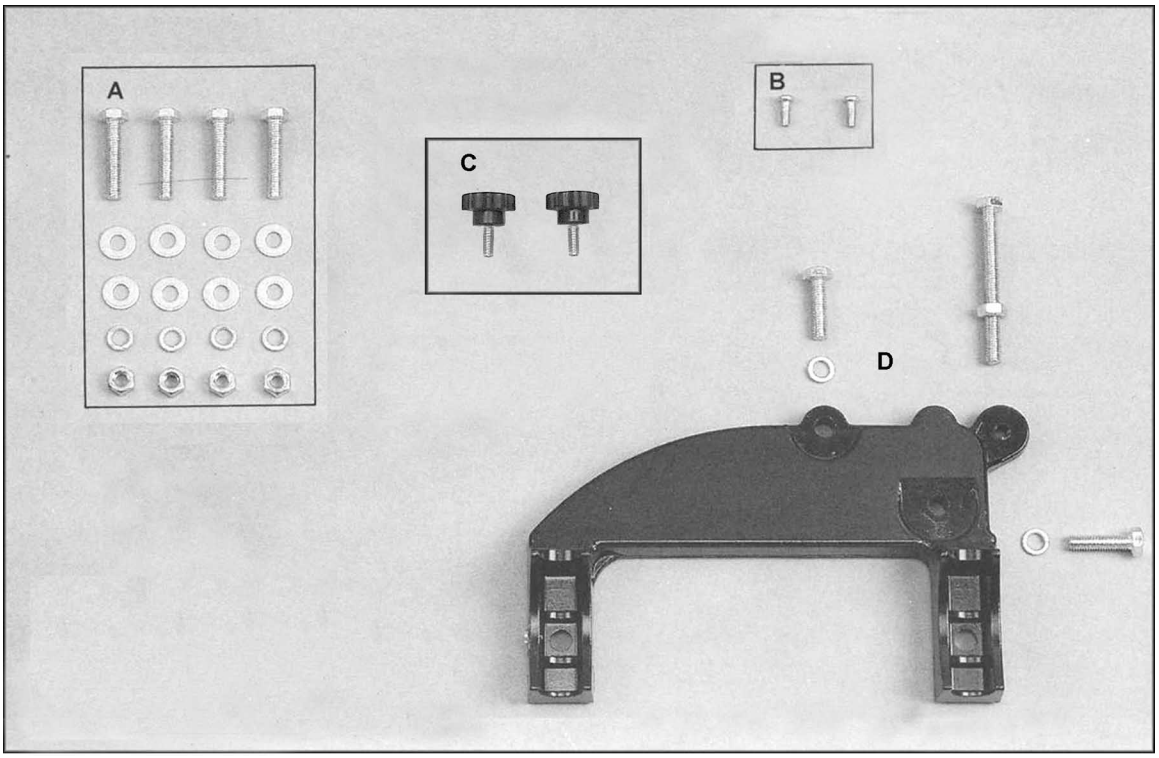
Open both shipping containers and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

## Contents of the Shipping Container

Container One:
1 Closed stand with motor
1 Pulley cover
1 V-belt

Container Two:
1 Saw body
1 Table
2 Table lock knobs
1 Table pin
1 Trunnion support bracket
1 Fastener package (see below)
1 Instruction Manual
1 Warranty Card

## Fasteners




**A. Saw Body to Stand**
4 – M8x40 hex cap screws (approx. 1-1/2" long)
8 – M8 flat washers
4 – M8 lock washers
4 – M8 hex nuts

**B. Strain Relief Plate to Stand**
2 – M5x12 pan head machine screws

**C. Pulley Cover to Base**
2 – Knobs

**D. Trunnion Support Bracket to Saw Body**
2 – M8x30 hex cap screws (approx. 1-1/4" long)
2 – M8 lock washers
1 – M8x80 hex cap screw (for table stop - approx. 3-1/8" long)
1 – M8 hex nut (for table stop)

# Assembly of JWBS-14OS

NOTE: If any of the assembly procedures need further clarification, refer to the exploded views in the back of this manual.

**Tools Required for Assembly**

Metric combination wrench set and adjustable wrench

#1 and #2 cross point screwdrivers

1. Place stand top upside down on a level surface. Fasten four stand legs to stand top using carriage bolts, washers, lock washers, and nuts, as shown in item A on page 7. Note: Stand legs fasten to outside of stand top (Figure 1). Do not tighten at this time.
2. Fasten two long braces and two short braces to stand legs using carriage bolts, washers, lock washers, and nuts, as shown in item A, page 7. Do not tighten at this time. See Figure 2.
3. Turn assembly over and stand it on its legs. Push down slightly on the top to make sure the stand settles properly and all four legs sit flat on a level surface. Tighten all nuts.

*Figure 1*

*Figure 2*

**⚠WARNING Saw body is heavy! Use caution when lifting and stabilize until firmly attached to the stand! Failure to comply may cause serious injury!**

4. With the aid of a second person, lift the saw body out of the shipping container and place onto the stand top. Be sure front of saw (with JET logo) faces stand front (JET logo). See photo on cover for orientation.
5. Line up holes in saw body with holes in stand. Place support plate to the underside of stand as shown in the parts diagram for the open stand assembly (item 5, page 30). Fasten saw body, stand, and support plate together with four hex cap screws, eight flat washers, four lock washers, and four hex nuts, as shown in item B on page 7.
6. To mount the motor, place four rubber grommets over holes in stand top (Figure 3). Note: Use of rubber grommets is essential for eliminating excessive vibration.

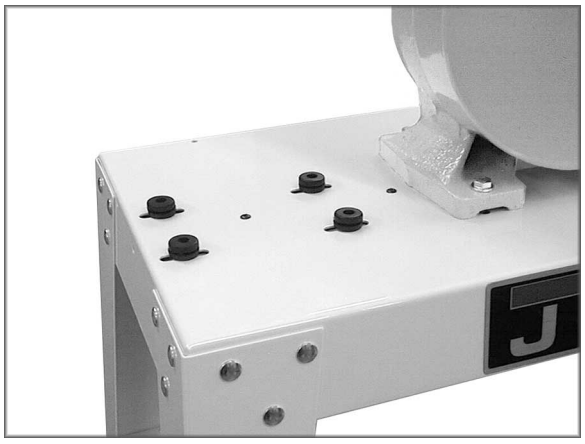


*Figure 3*

7. Place motor over rubber grommets and fasten to stand top with four hex cap screws, eight flat washers, four lock washers, and four hex nuts, as shown in item C, page 7. See Figure 4. The arrangement of these fasteners is shown in Figure 5. Do not tighten at this time.

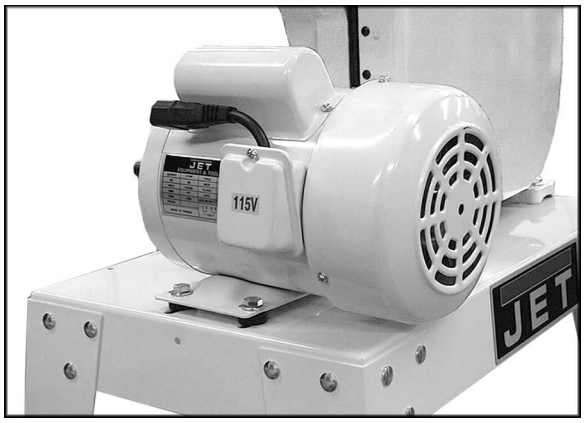



*Figure 4*

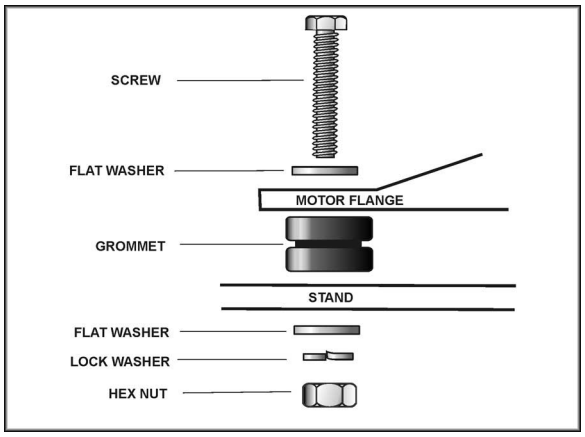



*Figure 5*

8. Align the motor pulley with the large pulley using a straight edge against the flat sides of the pulleys, as shown in Figure 6. The pulleys should lie in a straight plane (Figure 7). Slide the motor as needed to align the pulleys. If further adjustment is required, loosen the set screw in one or more of the pulleys and move the pulley(s) until they line up. Tighten set screw(s).

   **IMPORTANT**: When moving the pulleys, do not position them beyond the end of the shaft. Both pulleys must fully engage the shaft and the key.

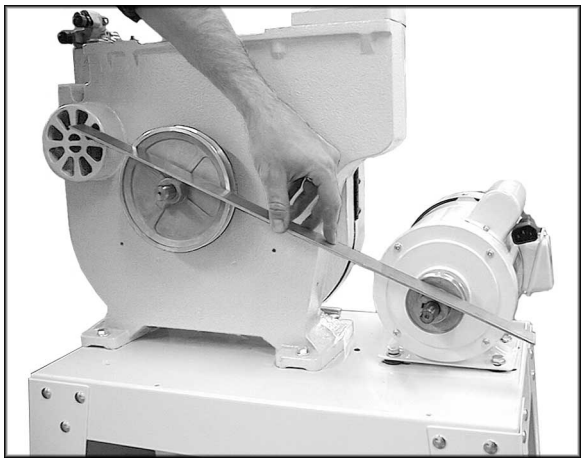


*Figure 6*

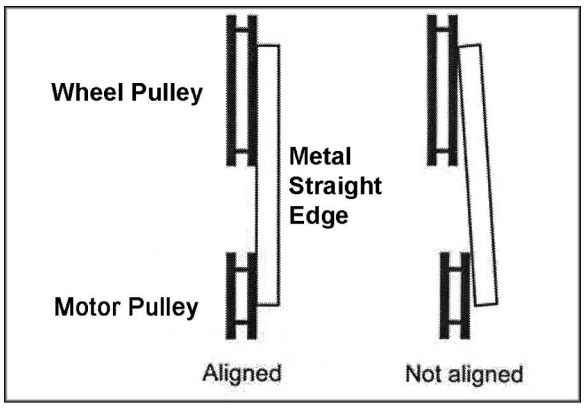



*Figure 7*

9. Place v-belt over both pulleys. See Figure 8.

10. Tension v-belt by moving motor away from the saw body and tighten the motor mount nuts. (Do not over-tighten motor mount bolts. Tighten just enough to tension belt.) Belt is properly tensioned when finger pressure between the two pulleys (Figure 8) causes approximately 1/2" deflection.

11. Place pulley cover over both pulleys and fasten to stand using three pan head screws, six washers, and three hex nuts, as shown in item D, page 7. See Figure 9.

12. Attach trunnion support bracket to saw body with two hex cap screws and two lock washers as shown in item E, page 7. See Figure 10.

13. Thread nut onto table stop bolt (Figure 10) and attach to trunnion support bracket.

14. To mount table, remove table insert and table pin (see Figure 11). Orient the table so that the saw blade will pass through the slot in the table and into the center opening. Continue holding up the table, and turn the table so the two screws that are hanging vertically from below the table will slide into the holes on the trunnion support bracket. Lower the table. The screws should now protrude below the trunnion support bracket - attach lock knobs to the ends of these screws. See Figure 11.

15. Re-install table insert and table pin.

16. Join motor plug to switch plug.

17. Transportation and handling may have caused some fasteners to loosen. Before operating, check all screws, bolts, and nuts to make sure they are snug. Operate machine only after reading the entire manual including blade tracking, blade guide adjustments, and safety rules.

18. Exposed metal surfaces, such as the table, have been given a protective coating. This should be cleaned with a soft cloth and solvent, such as kerosene. Do not use acetone, gasoline, or lacquer thinner. Do not use an abrasive pad, and do not get solvents on plastic parts.

Proceed to "Grounding Instructions" on page 14.

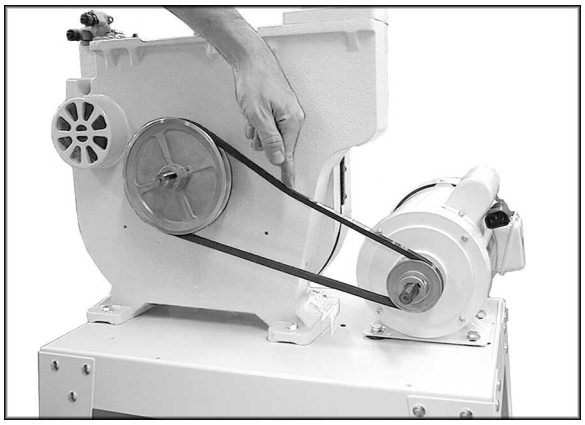


*Figure 8*

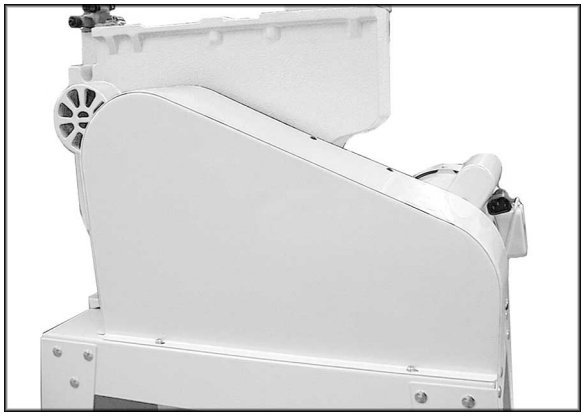


*Figure 9*

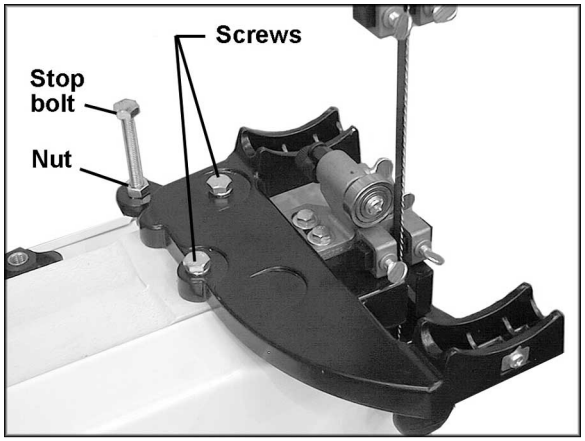



*Figure 10*

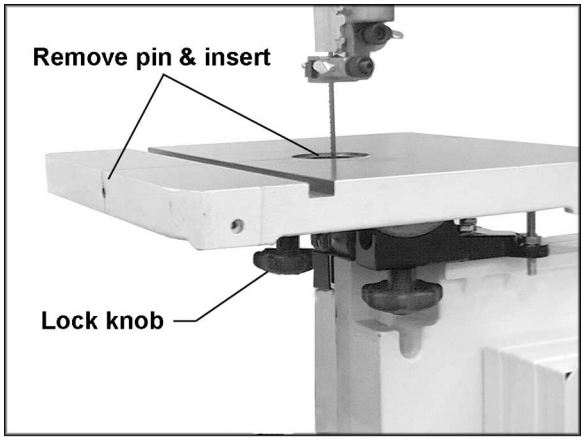



*Figure 11*

# Assembly of JWBS-14CS

**Tools Required for Assembly**

Metric combination wrench set and
adjustable wrench
#1 and #2 cross point screwdrivers

Exposed metal surfaces, such as the table, have been given a protective coating. This should be cleaned with a soft cloth and solvent, such as kerosene. Do not use an abrasive pad, and do not get solvents on plastic parts.

1. Remove pulley cover from inside of stand.

2. Place cabinet stand upright on a level surface. If desired, the stand can be further stabilized by securing it to the floor with lag screws through the inside corner holes. If using a mobile base, lock the casters before assembling or operating the band saw.

**⚠WARNING Saw body is heavy! Use caution when lifting and stabilize until firmly attached to the stand! Failure to comply may cause serious injury!**

3. With the aid of a second person, lift the saw body out of the shipping container and place onto stand top. Be sure front of saw (with JET logo) faces stand front (JET logo).

4. Line up holes in saw body with holes in top of stand. Fasten saw body to the stand with four M8 x 40 hex cap screws, eight M8 washers, four M8 lock washers, and four M8 hex nuts (as shown in item A, page 8).

5. Push motor cord and strain relief plate through the opening in the side of the stand (Fig. 12). Fasten the strain relief plate to the stand with two M5 x 12 pan head machine screws (shown in item B, page 8).

6. Check the alignment of the pulleys by placing a straight edge against the flat sides of the motor and wheel pulleys (Figure 13). If the pulleys lie in a straight plane (Figure 14) they are aligned. If they do not lie in a straight plane, loosen the set screw on one of the pulleys and shift the pulley in or out until both pulleys lie in a straight plane. Tighten set screw.

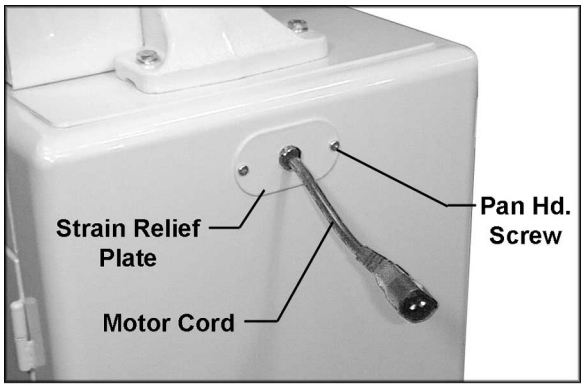



*Figure 12*

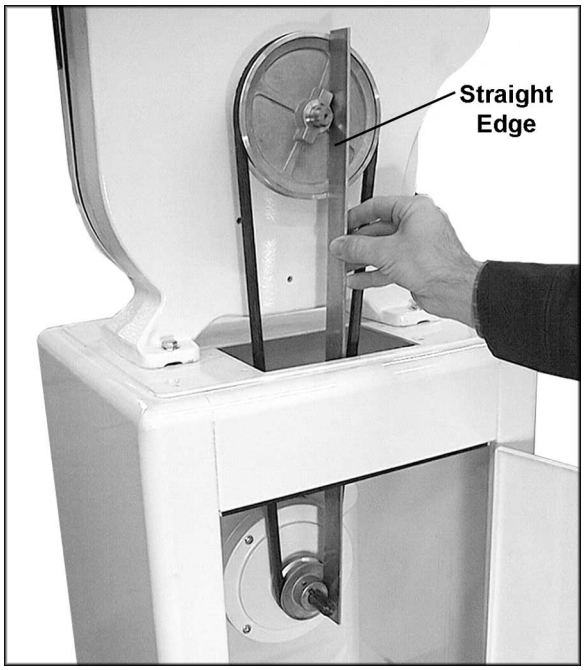



*Figure 13*

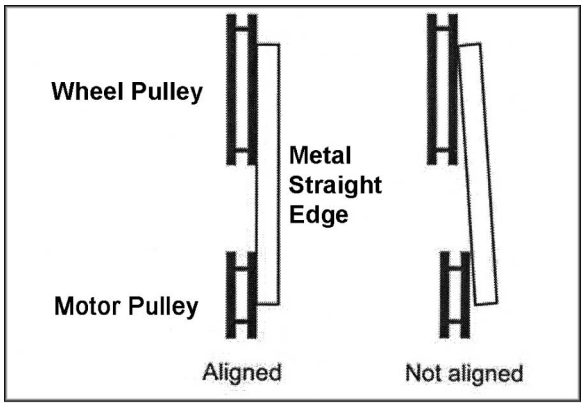



*Figure 14*

**IMPORTANT**: When moving the pulleys, do not position them beyond the end of the shaft. Both pulleys must fully engage the shaft and the key.

7. Open the lower door, and place the v-belt around the motor pulley and the wheel pulley (see Figure 13).

8. Loosen the nuts on the four motor mounting bolts (Figure 15) and tension the v-belt by pushing down on the motor. Tighten the four motor mounting nuts.

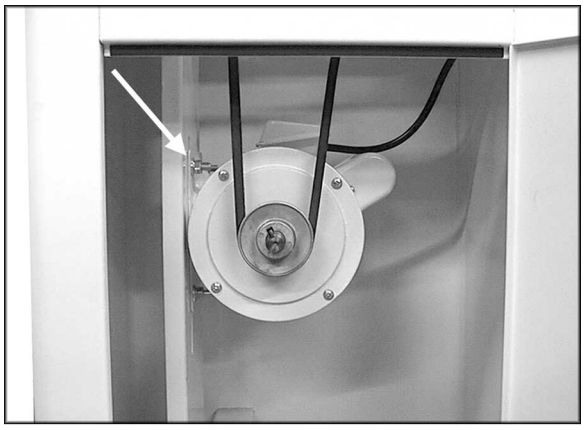


*Figure 15*

9. The v-belt is properly tensioned when finger pressure between the two pulleys causes approximately 1/2" deflection (Figure 16).

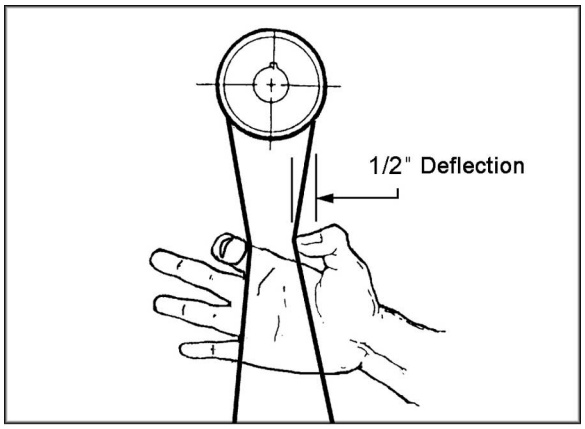



*Figure 16*

10. Screw the two small knobs (Figure 17) into the threaded holes in the saw body. Slide the pulley cover down over the knobs, and tighten the knobs.

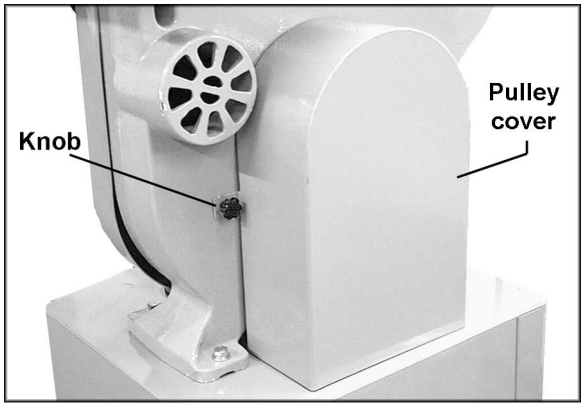



*Figure 17*

11. Attach trunnion support bracket to saw body with two M8 x 30 hex cap screws and two M8 lock washers, as shown in item D, page 8. See Figure 18.

12. Thread nut onto table stop bolt (Figure 18) and attach to trunnion support bracket as shown.

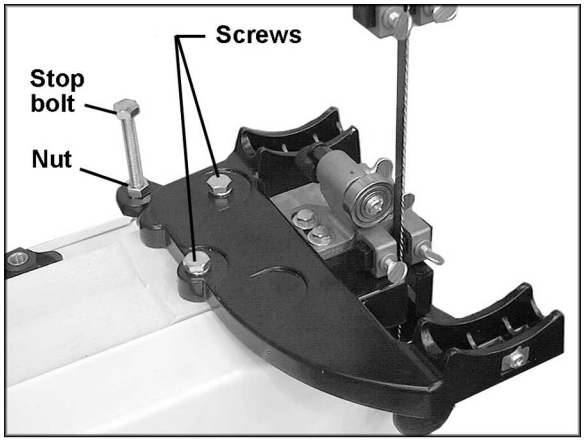



*Figure 18*

13. To mount the table, remove pin and insert from the table (Figure 19).

14. Orient the table so the saw blade will pass through the slot in the table and into the center opening. Continue holding up the table, and rotate the table so the two screws that are hanging vertically from below the table will slide into the holes on the trunnion support bracket. Lower the table. The screws should now protrude below the trunnion support bracket - attach lock knobs to the ends of these screws. (Figure 19).

15. Re-install table insert and table pin.

16. Connect the plugs of the motor cord and switch cord (Figure 20).

17. Transportation and handling may have caused some fasteners to loosen. Before operating, check all screws, bolts, and nuts to make sure they are snug. Operate machine only after reading the entire manual including blade tracking, blade guide adjustments, and safety rules.

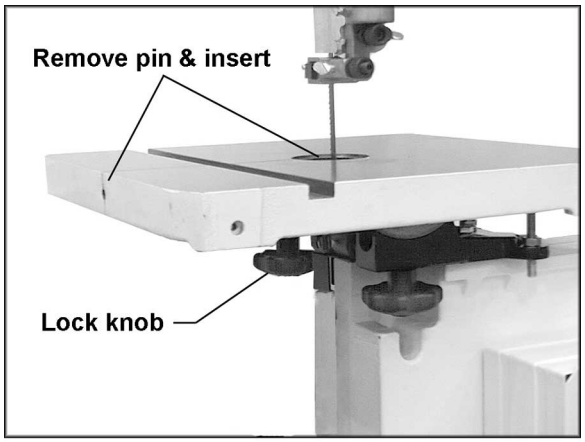



*Figure 19*

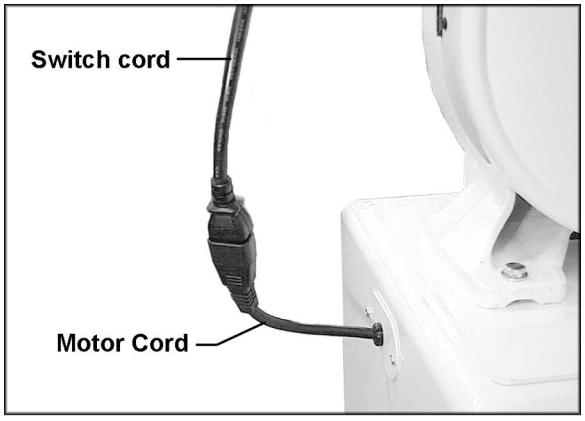



*Figure 20*

# Grounding Instructions

**⚠WARNING This band saw must be grounded while in use to protect the operator from electric shock.**

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug that looks similiar to the plug in Figure 21. The plug must be inserted into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

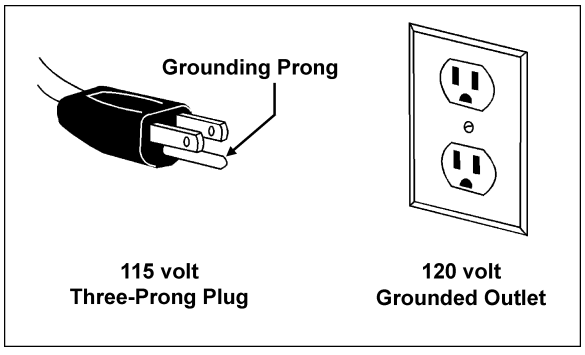



*Figure 21*

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Repair or replace a damaged or worn cord immediately.

## 115 Volt Operation

As received from the factory, your bandsaw is ready to run at 115 volt operation. This bandsaw, when wired for 115 volts, is intended for use on a circuit that has an outlet and a plug that looks like the one illustrated in Figure 21. A temporary adapter, like the adapter in Figure 22, may be used to connect this plug to a two-pole receptacle, as shown in Figure 22, if a properly grounded outlet is not available. The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. **This adapter is not applicable in Canada.** The green colored rigid ear, lug, or tab, extending from the adapter, must be connected to a permanent ground such as a properly grounded outlet box, as shown in Figure 22.

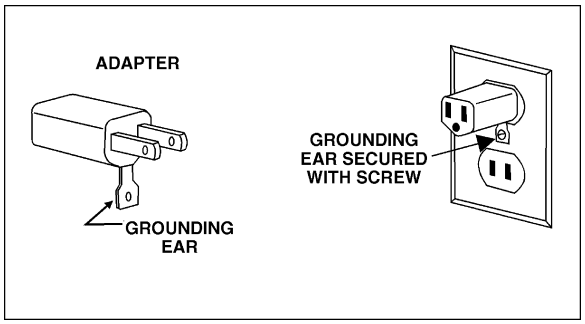



*Figure 22*

## 230 Volt Conversion

If 230V, single-phase operation is desired, the following instructions must be followed:

1. Disconnect machine from power source.
2. This band saw is supplied with four motor leads that are connected for 115V operation, as shown in Figure 23. Reconnect these four motor leads for 230V operation, as shown in Figure 23.
3. The 115V attachment plug supplied with the band saw must be replaced with a UL/CSA listed plug suitable for 230V operation, as shown in Figure 24. Contact your local authorized WMH Tool Group service center or qualified electrician for proper procedures to install the plug. The band saw must comply with all local and national codes after the 230 volt plug is installed.
4. The band saw with a 230 volt plug should only be connected to an outlet having the same configuration (Figure 24). No adapter is available or should be used with the 230 volt plug.

**Important: In all cases (115 or 230 volts), make certain the receptacle in question is properly grounded. If you are not sure, have a registered electrician check the receptacle.**

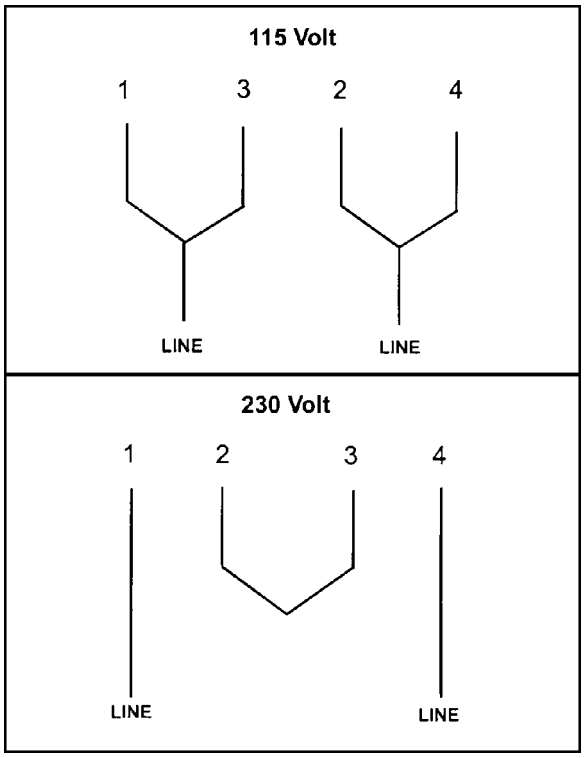



*Figure 23*

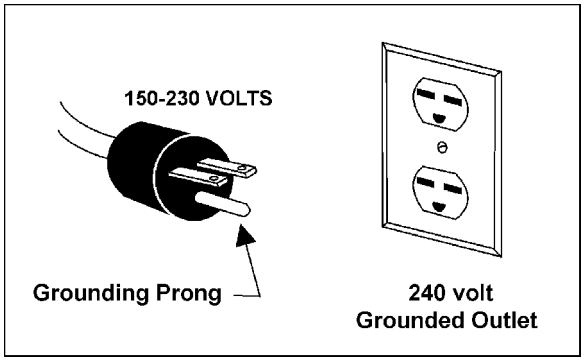



*Figure 24*

### Extension Cords

Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.

Make sure the cord is in good condition, and heavy enough to carry the current your band saw will draw. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. Figure 25 shows the correct size to use depending on cord length and the ampere rating on your machine's nameplate. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Repair or replace a damaged or worn cord immediately.

| Minimum Gauge Extension Cord | | | |
|---|---|---|---|
| *Amp rating* | *Line voltage* | *Total length of cord in feet* | *Cord gauge (AWG)* |
| 0-6 | 120 | 0 to 25 | 18 |
| | | 25 to 50 | 16 |
| | | 50 to 100 | 16 |
| | | over 100 | 14 |
| 6-10 | 120 | 0 to 25 | 18 |
| | | 25 to 50 | 16 |
| | | 50 to 100 | 14 |
| | | over 100 | 12 |
| 10-12 | 120 | 0 to 25 | 16 |
| | | 25 to 50 | 16 |
| | | 50 to 100 | 14 |
| | | over 100 | 12 |
| 12-16 | 120 | 0 to 25 | 14 |
| | | 25 to 50 | 12 |
| | | over 50 | not recommended |

*Figure 25*

# Adjustments

**⚠WARNING Unplug the machine from the power source before making any repairs or adjustments. Failure to comply may cause serious injury.**

### Tilting the Table

1. Loosen two lock knobs (Figure 26).
2. Tilt table up to 45 degrees to the right or up to 10 degrees to the left. The angle can be read on the scale mounted to the trunnion.
3. Tighten two lock knobs (Figure 26).

Note: Table stop must be removed to tilt table to the left.

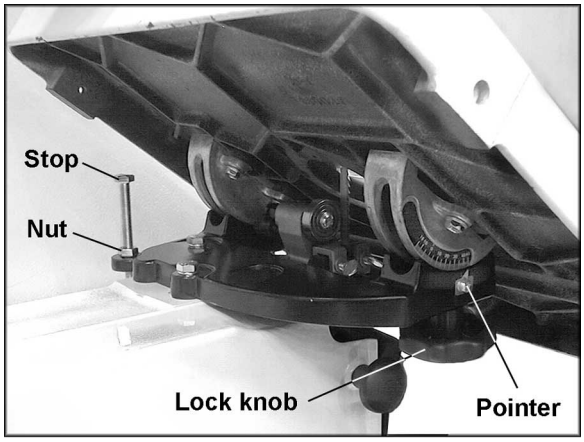



*Figure 26*

### Adjusting 90° Table Stop

1. Disconnect machine from power source.
2. Loosen lock knobs (Figure 26) and tilt table left until it rests against the table stop.
3. Use a square placed on the table and against the blade (Figure 27) to see if the table is 90 degrees to the blade.
4. If an adjustment is necessary, loosen lock knobs, tilt table to the right, and lock in place.

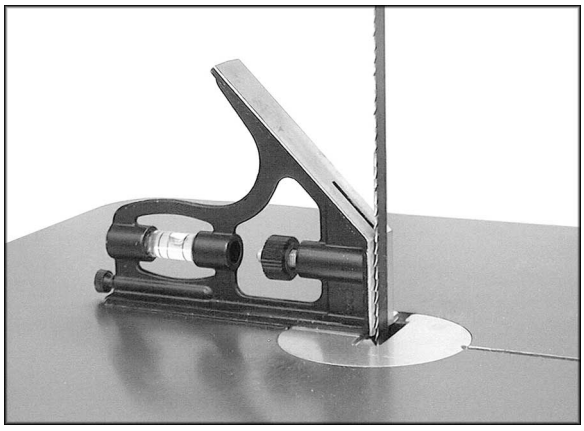


*Figure 27*

5. Loosen jam nut and turn table stop (Figure 26) left or right to raise or lower the stop. Tighten jam nut to hold table stop in place.

6. Unlock table, tilt back onto table rest and confirm table is 90 degrees with the blade.

7. If necessary, adjust scale pointer to zero.

## Changing Blades

**⚠WARNING Blade teeth are sharp! Use care when handling the saw blade. Failure to comply may cause serious injury.**

1. Disconnect machine from power source.

2. Loosen blade tension by turning the tension knob counterclockwise (Figure 28).

3. Remove the table insert and the table pin.

4. Open both wheel covers.

5. Remove the blade from between upper and lower blade guides. Remove blade from upper and lower wheels. Turn blade to direct through slot in table.

6. Guide new blade through table slot. Place blade in upper and lower blade guides. **Note:** The blade teeth should face the operator, and they should point down toward the table.

7. Place blade in the middle of the upper and lower wheel.

8. Re-install table insert and table pin.

9. Tension and track blade before operating saw. Find instructions for tensioning and tracking the blade under "Adjusting Blade Tension" and "Adjusting Blade Tracking".

## Adjusting Blade Tension

1. Disconnect machine from power source.

2. Turn blade tension knob (Figure 28) clockwise to tension blade. A gauge on the upper wheel slide bracket indicates the approximate tension according to the width of the blade. Initially, set the blade tension to correspond to the blade width as marked on the gauge.

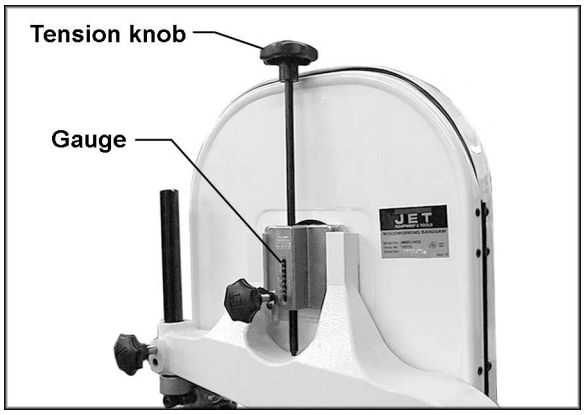



*Figure 28*

3. As you become more experienced with the saw, you may find it necessary to change the blade tension from the initial setting. Changes in blade width and the type of material being cut will have an effect on blade tension.

4. Keep in mind that too little or too much blade tension can cause blade breakage.

## Adjusting Blade Tracking

**⚠WARNING Disconnect machine from the power source. Never adjust blade tracking with the machine running. Failure to comply may cause serious injury.**

"Tracking" refers to how the blade is situated upon the wheels while in motion. The blade should track in the center of both wheels.

1. The blade must be properly tensioned before adjusting blade tracking. Make sure blade guides and blade bearings do not interfere with the blade.

2. Open the top wheel cover. Rotate the wheel forward by hand, and observe the position of the blade on the wheel - it should be in the center of the wheel.

3. If adjustment is necessary, loosen wing nut (Figure 29), and tighten tracking knob slightly to move blade toward rear of machine. Slightly loosening the tracking knob will cause the blade to track toward the front of the machine.

4. After blade is tracking in the center of the wheel, tighten the wing nut.

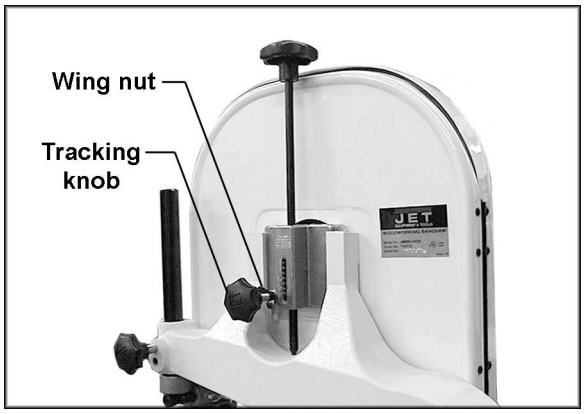



*Figure 29*

## Adjusting Upper Blade Guide Assembly

1. Disconnect machine from power source.

2. Loosen lock knob (A, Figure 30) and raise or lower upper blade guide assembly (B, Figure 30) to just above the material being cut.

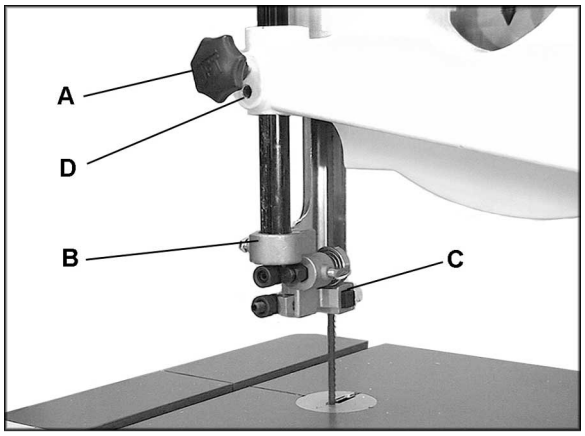



*Figure 29*

3. Tighten lock knob. Make sure blade guide blocks (C, Figure 30) are still flat to the blade. If adjustment is necessary, loosen lock knob (A, Figure 30) and rotate assembly until guide blocks are flat to blade.

4. If movement of the blade guide assembly seems “stiff” when being raised or lowered, it can be adjusted to slide more easily. This is controlled by an internal spring and ball which provide varying degrees of resistance against the guide post. Use the set screw (D, Figure 30) to adjust the tension of this spring. To adjust tension on the spring, loosen knob (A, Figure 30), use a hex wrench to tighten or loosen set screw (D, Figure 30) until desired tension is reached, then re-tighten knob (A, Figure 30).

## Adjusting Blade Guide and Blade Support Bearing

**⚠WARNING Blade guard has been removed for picture clarity. Never operate the band saw without all guards in place and in working order.**

1. Disconnect machine from power source.

2. Blade must already be tensioned and tracking properly.

3. Loosen thumb screws (E, Figure 31) and move guide blocks (C, Figure 31) as close to the blade as possible without pinching it.

4. Tighten thumb screws (E, Figure 31).

5. Loosen thumb screw (F, Figure 31) and turn knurled knob (G, Figure 31) to move the guide block bracket in or out until the front edge of the guide blocks are just behind the "gullets" of the saw teeth.

6. Tighten thumb screw (F, Figure 31).

7. The blade support bearing (K, Figure 31) should be adjusted so that the back edge of the blade overlaps the front face of the ball bearing approximately 1/8". To change position of the bearing, remove screw (L, Figure 31), and bearing (K, Figure 31). Loosen thumb screw (H, Figure 31) and back off knurled knob (J, Figure 31) completely to remove the bearing shaft.

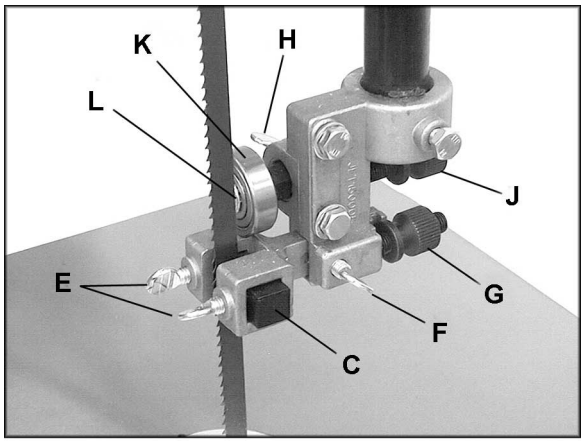



*Figure 31*

8. Notice the bearing holder on the shaft is eccentric. Index the bearing shaft to another position and slide it back in, making sure the flange on the thumb screw (H, Figure 31) properly seats into the groove of the bearing shaft. Re-install the bearing and the screw. Examine the overlap between the bearing face and the blade. Change the position of the bearing shaft until the overlap is approximately 1/8".

9. With the thumb screw (H, Figure 31) still loosened, adjust the distance from bearing to blade. Turn knurled knob (J, Figure 31) to move the support bearing (K, Figure 31) in or out until the bearing is 1/64" behind the blade. (NOTE: To set this distance quickly, you can place a dollar bill or piece of paper between support bearing and back of blade.)

10. Tighten thumb screw (H, Figure 31).

11. Repeat procedures 1 through 10 for the Lower Blade Guide Assembly.

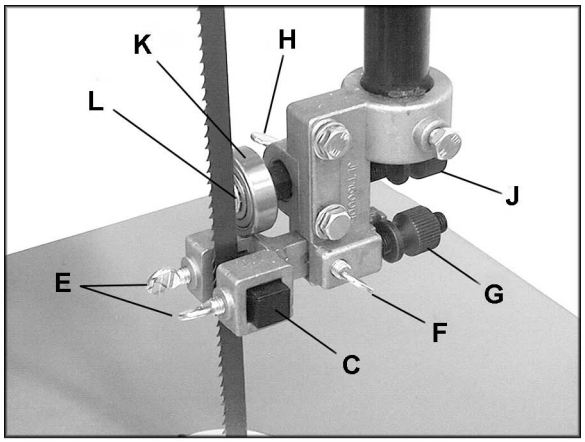



*Figure 31*
*(repeated)*

# Troubleshooting JWBS-14CS/OS Band Saw

| Trouble | Probable Cause | Remedy |
|---|---|---|
| Saw stops or will not start. | Saw unplugged. | Check all plug connections. |
| | Fuse blown, or circuit breaker tripped. | Replace fuse, or reset circuit breaker. |
| | Cord damaged. | Replace cord. |
| Does not make accurate 45 or 90 degree cuts. | Table stop not adjusted correctly. | Check blade with square and adjust table stop. |
| | Angle pointer not set accurately. | Check blade with square and adjust pointer. |
| | Miter gauge out of adjustment. | Adjust miter gauge. |
| Blade wanders during cut. | Fence not aligned with blade. | Check and adjust fence (see fence manual). |
| | Warped wood. | Select another piece of wood. |
| | Excessive feed rate. | Reduce feed rate. |
| | Incorrect blade for cut. | Change blade to correct type. |
| | Blade tension not set properly. | Set blade tension according to blade size. |
| | Guides not set properly. | Adjust guides. |
| Saw makes unsatisfactory cuts. | Dull blade. | Replace blade. |
| | Blade mounted wrong. | Teeth should face operator and point downward. |
| | Gum or pitch on blade. | Remove blade and clean with oven cleaner or other solvent. |
| | Incorrect blade for cut. | Change blade to correct type. |
| | Gum or pitch on table. | Clean table. |
| Blade does not come up to speed. | Extension cord too light or too long. | Replace with adequate size and length cord. |
| | Low shop voltage. | Contact your local electric company. |
| Saw vibrates excessively. | Base on uneven floor. | Reposition on flat, level surface. |
| | Bad v-belt. | Replace v-belt. |
| | Motor mounting is loose. | Tighten motor mount fasteners. |
| | Loose fasteners. | Tighten fasteners. |

# Optional Accessories

708114 **Three speed kit for JWBS-14CS**
Produces speeds of 965, 1470, and 2465 SPFM. Includes four step motor pulley, intermediate pulley, V-belts, fasteners, and mounting instructions with parts list.

708718 **JRF-14 Rip Fence Assembly**
Includes guide bars, rip fence assembly, fasteners, and mounting instructions with parts list.

708717 **JRB-14 Riser Block Kit**
Increases depth of cut from 6" maximum to 12" maximum. Includes 6" cast block, long frame bolt, front and back blade guards, 105" blade, and mounting instructions with parts list.

708716 **JMG-14 Miter Gauge Assembly**
For straight and angle cutting. Includes guide bar, pivoting support body, and adjustable stops.

708719 **JRB-14 Blade Block Set**
Includes upper and lower replacement blocks made from a non-metallic composite material with a dry lubricant to reduce friction and heat.

708127 **JRBG-14 Roller Bearing Guides**
Dual bearing system maximizes contact and minimizes friction against the blade. Includes upper and lower guide assemblies, mounting studs, adaptor blocks, and mounting hardware.

## Accessory Blades

| Blade | Width (in.) | Length (in.) | TPI | Type | Gauge (in.) | Stock Number |
|---|---|---|---|---|---|---|
| Carbon steel | 1/8 | 93-1/2 | 14 | Hook | 0.020 | 709370 |
| Carbon steel | 3/16 | 93-1/2 | 6 | Skip | 0.020 | 709371 |
| Carbon steel | 1/4 | 93-1/2 | 6 | Skip | 0.020 | 709372 |
| Carbon steel | 3/8 | 93-1/2 | 4 | Skip | 0.020 | 709373 |
| Carbon steel | 1/2 | 93-1/2 | 4 | Hook | 0.020 | 709374 |
| Carbon steel | 3/4 | 93-1/2 | 4 | Hook | 0.020 | 709375 |
| Carbon steel | 1/8 | 105 | 14 | Hook | 0.020 | 709376* |
| Carbon steel | 3/16 | 105 | 6 | Skip | 0.020 | 709377* |
| Carbon steel | 1/4 | 105 | 6 | Skip | 0.020 | 709378* |
| Carbon steel | 3/8 | 105 | 4 | Skip | 0.020 | 709379* |
| Carbon steel | 1/2 | 105 | 4 | Hook | 0.020 | 709380* |
| Carbon steel | 3/4 | 105 | 4 | Hook | 0.020 | 709381* |
| Premium alloy | 1/8 | 93-1/2 | 14 | Raker | 0.025 | 709351 |
| Premium alloy | 3/16 | 93-1/2 | 4 | Skip | 0.025 | 709352 |
| Premium alloy | 1/4 | 93-1/2 | 6 | Hook | 0.025 | 709354 |
| Premium alloy | 1/4 | 93-1/2 | 14 | Raker | 0.025 | 709355 |
| Premium alloy | 3/8 | 93-1/2 | 4 | Hook | 0.025 | 709356 |
| Premium alloy | 3/8 | 93-1/2 | 14 | Raker | 0.025 | 709274 |
| Premium alloy | 1/2 | 93-1/2 | 3 | Hook | 0.025 | 709357 |
| Premium alloy | 1/2 | 93-1/2 | 6 | Hook | 0.025 | 709358 |
| Premium alloy | 3/4 | 93-1/2 | 3 | Hook | 0.032 | 709359 |
| Premium alloy | 3/4 | 93-1/2 | 10 | Raker | 0.035 | 709226 |
| Premium alloy | 1/8 | 105 | 14 | Raker | 0.025 | 709361* |
| Premium alloy | 3/16 | 105 | 4 | Skip | 0.025 | 709362* |

| Blade | Width (in.) | Length (in.) | TPI | Type | Gauge (in.) | Stock Number |
|---|---|---|---|---|---|---|
| Premium alloy | 1/4 | 105 | 6 | Hook | 0.025 | 709364* |
| Premium alloy | 1/4 | 105 | 14 | Raker | 0.025 | 709365* |
| Premium alloy | 3/8 | 105 | 4 | Hook | 0.025 | 709366* |
| Premium alloy | 3/8 | 105 | 14 | Raker | 0.025 | 709275* |
| Premium alloy | 1/2 | 105 | 3 | Hook | 0.025 | 709367* |
| Premium alloy | 1/2 | 105 | 6 | Hook | 0.025 | 709368* |
| Premium alloy | 3/4 | 105 | 3 | Hook | 0.032 | 709369* |
| Premium alloy | 3/4 | 105 | 10 | Raker | 0.032 | 709276* |
| Silicon steel | 3/16 | 93-1/2 | 10 | Raker | 0.025 | 709588 |
| Silicon steel | 3/8 | 93-1/2 | 6 | Hook | 0.025 | 709589 |
| Silicon steel | 3/8 | 93-1/2 | 10 | Raker | 0.025 | 709590 |
| Silicon steel | 3/8 | 93-1/2 | 14 | Raker | 0.025 | 709591 |
| Silicon steel | 1/2 | 93-1/2 | 4 | Hook | 0.025 | 709592 |
| Silicon steel | 1/2 | 93-1/2 | 6 | Hook | 0.025 | 709593 |
| Silicon steel | 3/4 | 93-1/2 | 3 | Hook | 0.032 | 709488 |
| Silicon steel | 3/4 | 93-1/2 | 10 | Raker | 0.032 | 709489 |
| Silicon steel | 3/16 | 105 | 10 | Raker | 0.025 | 709594* |
| Silicon steel | 3/8 | 105 | 6 | Hook | 0.025 | 709595* |
| Silicon steel | 3/8 | 105 | 10 | Raker | 0.025 | 709596* |
| Silicon steel | 3/8 | 105 | 14 | Raker | 0.025 | 709597* |
| Silicon steel | 1/2 | 105 | 4 | Hook | 0.025 | 709598* |
| Silicon steel | 1/2 | 105 | 6 | Hook | 0.025 | 709599* |
| Silicon steel | 3/4 | 105 | 3 | Hook | 0.032 | 709517* |
| Silicon steel | 3/4 | 105 | 10 | Raker | 0.032 | 709518* |

* The 105” blades are for use with the optional riser block kit.

# Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 between 7:00 a.m. and 6:00 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

## Body Assembly (JWBS-14CS/OS Band Saw)

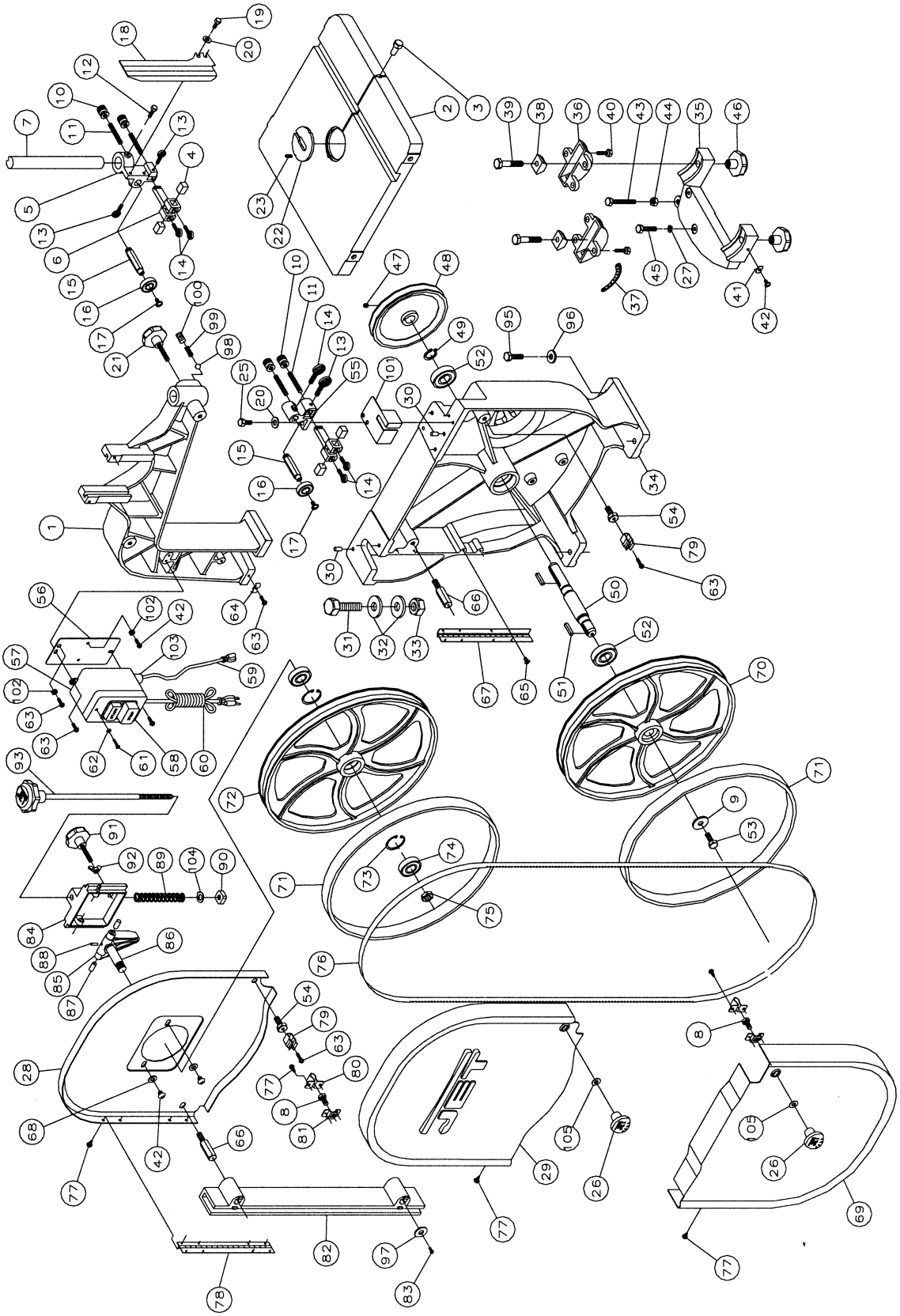
| Index No. | Part No. | Description | Size | Qty |
|---|---|---|---|---|
| 1 | 150100AW | Upper Arm Frame | | 1 |
| 2 | 150037W | Table | | 1 |
| 3 | 100038 | Table Pin | | 1 |
| 4 | 708719 | Guide Block | | 4 |
| 5 | 150005A | Upper Support Bracket Post | | 1 |
| 6 | 150006A | Support Bracket | | 2 |
| 7 | 150007A | Guide Post | | 1 |
| 8 | TS-1490021 | Hex Cap Screw | M8x16 | 2 |
| 9 | TS-1550061 | Flat Washer | M8 | 1 |
| 10 | 150010A | Nut | | 4 |
| 11 | 990708 | Screw | M8x40 | 2 |
| 12 | TS-1482031 | Hex Cap Screw | M6x16 | 1 |
| 13 | 150013A | Thumb Screw | M6x16 | 3 |
| 14 | 150014A | Thumb Screw | M6x12 | 5 |
| 15 | 150015A | Upper Spacing Sleeve | | 2 |
| 16 | BB-6200ZZ | Ball Bearing | | 2 |
| 17 | 990908 | Pan Head Screw* | M6x8 | 2 |
| 18 | 100002A | Upper Wheel Blade Guard | | 1 |
| 19 | TS-148201 | Hex Cap Screw | M6X10 | 2 |
| 20 | TS-1550041 | Washer | M6 | 4 |
| 21 | 990651 | Lock Knob | M10x30 | 1 |
| 22 | 199037 | Table Insert | | 1 |
| 23 | 992311 | Spring Pin | | 1 |
| 25 | TS-1482041 | Phillips Pan Head Machine Screw | M6x20 | 2 |
| 26 | 150024 | Catch Knob | | 2 |
| 27 | TS-1551061 | Lock Washer* | M8 | 2(2)* |
| 28 | 150028W | Inner Wheel Cover | | 1 |
| 29 | 155029W | Outer Wheel Cover | | 1 |
| 30 | 100031 | Pin | | 4 |
| 31 | 990180 | Hex Head Bolt | M16x55 | 1 |
| 32 | WF-164030 | Washer | M16 | 2 |
| 33 | TS-1540101 | Hex Nut | M16 | 1 |
| 34 | 100188 | Base | | 1 |
| 35 | 110045 | Trunnion Support Bracket | | 1 |
| 36 | 100042 | Trunnion | | 2 |
| 37 | 100051 | Scale | | 1 |
| 38 | 100041 | Trunnion Clamp Shoe | | 2 |
| 39 | TS-1491081 | Hex Cap Screw | M10x50 | 2 |
| 40 | TS-1482021 | Hex Cap Screw | M6x12 | 6 |
| 41 | 110049 | Pointer | | 1 |
| 42 | 990821 | Pan Head Screw | M5x6 | 5 |
| 43 | TS-1490151 | Hex Cap Screw* | M8x80 | 1 |
| 44 | TS-1540061 | Hex Nut* | M8 | 1 |
| 45 | TS-1490051 | Hex Cap Screw* | M8X30 | 2 |
| 46 | 990554 | Lock Knob | | 2 |
| 47 | TS-152303 | Set Screw | M6x10 | 1 |
| 48 | 100063 | Belt Pulley | | 1 |
| 49 | 992547 | Retaining Ring | | 1 |
| 50 | 110065 | Lower Wheel Shaft | | 1 |
| 51 | 992009 | Key | 5x5x20 | 2 |
| 52 | BB-6204RS | Ball Bearing | 6204RS | 2 |
| 53 | 990293 | Hex Head Bolt (Left Thread) | M8x25 | 1 |
| 54 | 150054 | Hex Head Bolt | | 2 |
| 55 | 150055 | Lower Support Bracket Post | | 1 |
| 56 | 150056 | Switch Backing Plate | | 1 |
| 57 | 523028 | Switch Box | | 1 |
| 58 | 994542 | Switch | | 1 |

## Body Assembly (JWBS-14CS/OS Band Saw)

| Index No. | Part No. | Description | Size | Qty |
|---|---|---|---|---|
| 59 | 995001 | Power Cord (Switch To Motor) | | 1 |
| 60 | 995002 | Power Cord (Switch To Power Soure) | | 1 |
| 61 | 990814 | Self Tapping Screw | M3.5x19 | 2 |
| 62 | TS-1550021 | Flat Washer | M4 | 2 |
| 63 | TS-1533042 | Phillips Pan Head Machine Screw | M5x12 | 6 |
| 64 | 523024 | Wire Clip | | 1 |
| 65 | TS-1533032 | Phillips Pan Head Machine Screw | M5x10 | 4 |
| 66 | 150066 | Stud | | 2 |
| 67 | 150902 | Lower Hinge | | 1 |
| 68 | WF051210 | Washer | M5 | 2 |
| 69 | 150069N | Lower Wheel Guard | | 1 |
| 70 | 198672 | Lower Wheel | | 1 |
| 71 | 100025A | Wheel Protector | | 2 |
| 72 | 198242 | Upper Wheel | | 1 |
| 73 | 992522 | Retaining Ring | R35 | 2 |
| 74 | BB-6202ZZ | Ball Bearing | 6202ZZ | 2 |
| 75 | TS-1540083 | Hex Nut | M12 | 1 |
| 76 | | Saw Blade (Local Purchase) | | 1 |
| 77 | 990804 | Self Tapping Screw | M4x8 | 16 |
| 78 | 150901 | Upper Hinge | | 1 |
| 79 | 150079 | Catch | | 2 |
| 80 | 150080 | Clip | | 2 |
| 81 | 150081 | Bracket | | 2 |
| 82 | 110070 | Blade Guard | | 1 |
| 83 | 990811 | Self Tapping Screw | M3.5x12 | 2 |
| | 100016ACP | Sliding Bracket Assy (includes items 84 thru 93, and 104) | | 1 |
| 84 | 100016A | Sliding Bracket | | 1 |
| 85 | 100019 | Shaft Hinge | | 1 |
| 86 | 150086 | Upper Wheel Shaft | | 1 |
| 87 | 100021 | Steel Pin | | 2 |
| 88 | 992314 | Spring Pin | | 1 |
| 89 | 100015A | Coil Spring | | 1 |
| 90 | 150090 | Square Nut | | 1 |
| 91 | 990652 | Lock Knob | | 1 |
| 92 | NW080000 | Wing Nut | M8 | 1 |
| 93 | 990653 | Blade Adjusting Screw | | 1 |
| 95 | TS-1490071 | Hex Cap Screw* | M8x40 | 4 |
| 96 | TS-1550061 | Flat Washer* | M8 | 4 |
| 97 | 150097 | Washer | | 2 |
| 98 | 994181 | Steel Ball | | 1 |
| 99 | 150099 | Spring | | 1 |
| 100 | TS-1525011 | Socket Set Screw | M10x10 | 1 |
| 101 | 150101 | Lower Wheel Blade Guard | | 1 |
| 102 | WE050000 | Gear Washer | M5 | 2 |
| 103 | 998654 | Strain Relief | | 2 |
| 104 | 100018 | Indicator | | 1 |
| 105 | WI080000 | Gear Washer | M8 | 2 |
| | JWBS14-HK | Hardware Kit (not shown) | | 1 |

* ..... included in hardware kit

## Body Assembly (JWBS-14CS/OS Band Saw)

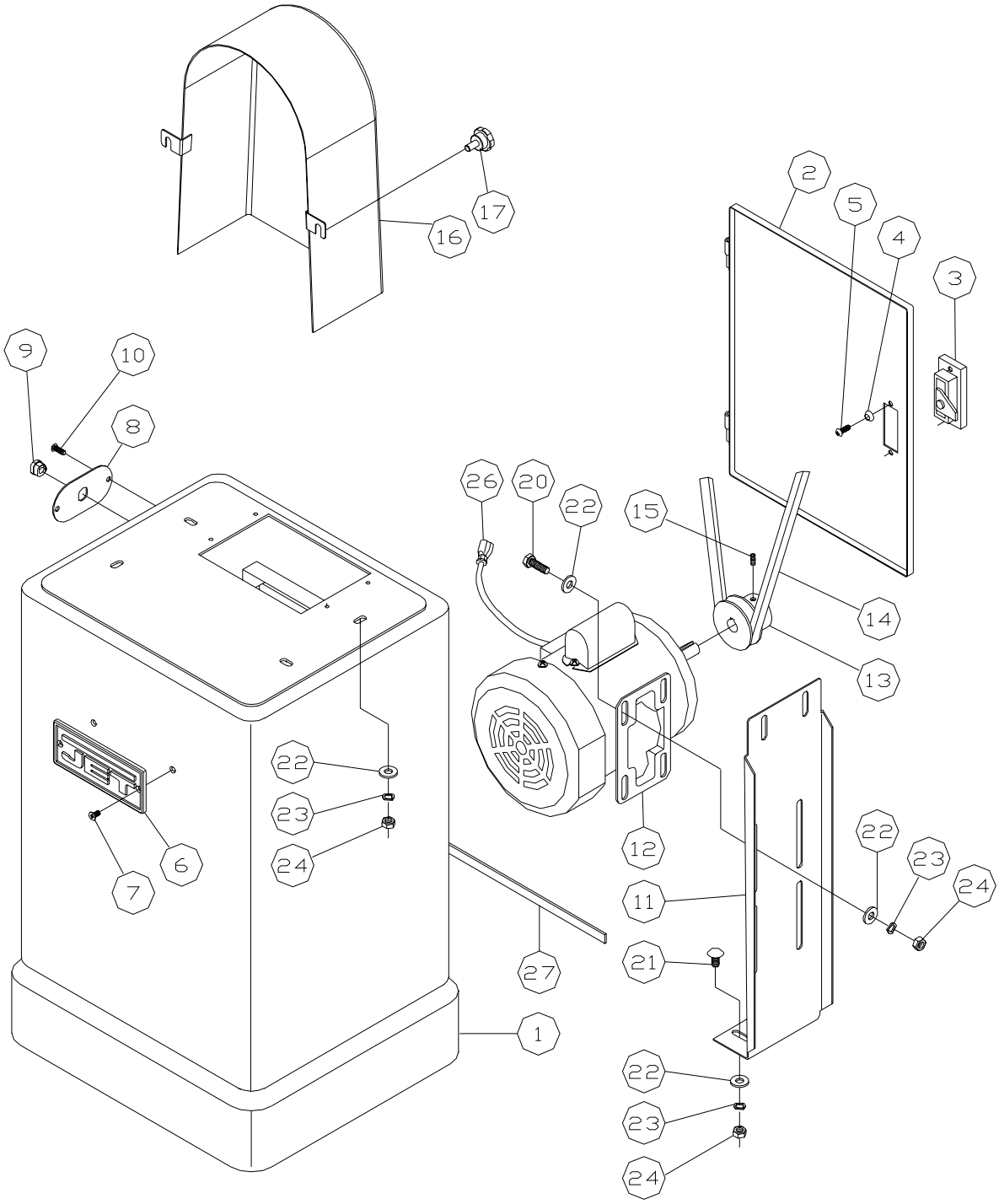


## Closed Stand Assembly (JWBS-14CS Band Saw)

| Index No. | Part No. | Description | Size | Qty |
|---|---|---|---|---|
| 1 | 150501W | Stand | | 1 |
| 2 | 150502W | Door | | 1 |
| 3 | 150503 | Door Latch Assembly | | 1 |
| 4 | WBS14CS-04 | Washer | | 2 |
| 5 | WBS14CS-05 | Pan Head Screw | M4x5 | 2 |
| 6 | PG-M02 | JET Plaque | | 1 |
| 7 | TS-1533031 | Flat Head Screw | M5x10 | 2 |
| 8 | 150508W | Plate | | 1 |
| 9 | 998621 | Strain Relief | | 1 |
| 10 | TS-1533042 | Phillips Pan Head Machine Screw* | M5x12 | 2 |
| 11 | 150511W | Motor Plate | | 1 |
| 12 | 150512W | Motor | 1HP, 1Ph, 115/230V | 1 |
| 13 | 600013 | Motor Pulley | | 1 |
| 14 | VB-A50 | V-BELT | | 1 |
| 15 | TS-1523011 | Socket Set Screw | M6x6 | 1 |
| 16 | 100254 | Pulley Box | | 1 |
| 17 | 990624 | Knob* | | 2 |
| 20 | TS-1490041 | Hex Cap Screw | M8x25 | 4 |
| 21 | 991516 | Square Neck Bolt | M8x16 | 4 |
| 22 | TS-1550051 | Flat Washer* | M8 | 16(4)* |
| 23 | TS-155108 | Lock Washer* | M8 | 12(4)* |
| 24 | TS-1540061 | Hex Nut* | M8 | 12(4)* |
| 26 | 995003A | Motor Cord | | 1 |
| 27 | 150527 | Pad | | 2 |
| | WBS14CS-HK | Hardware Kit (Not Shown) | | 1 |

* ..... included in hardware kit

## Closed Stand Assembly (JWBS14-CS Band Saw)

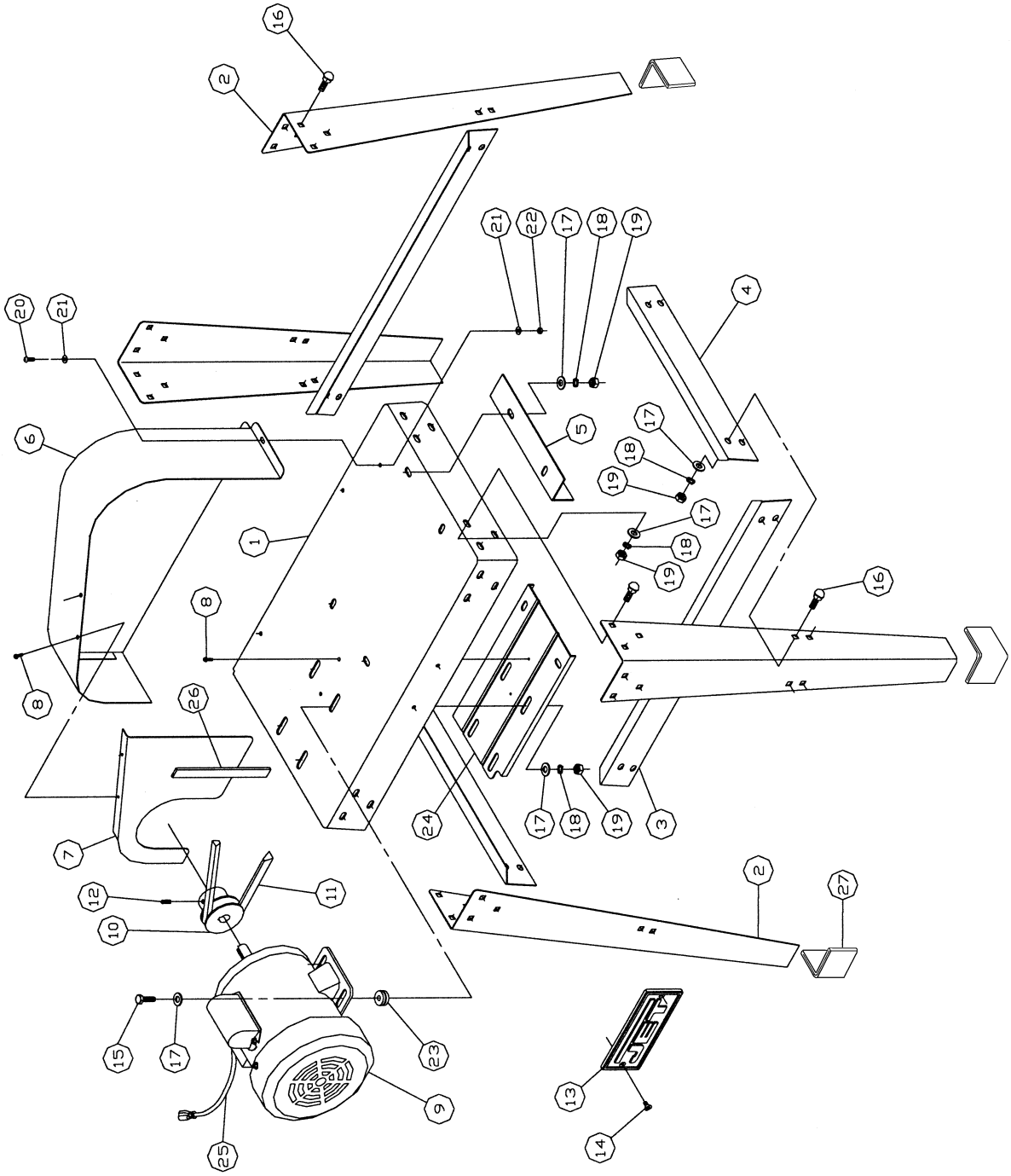


## Open Stand Assembly (JWBS-14OS Band Saw)

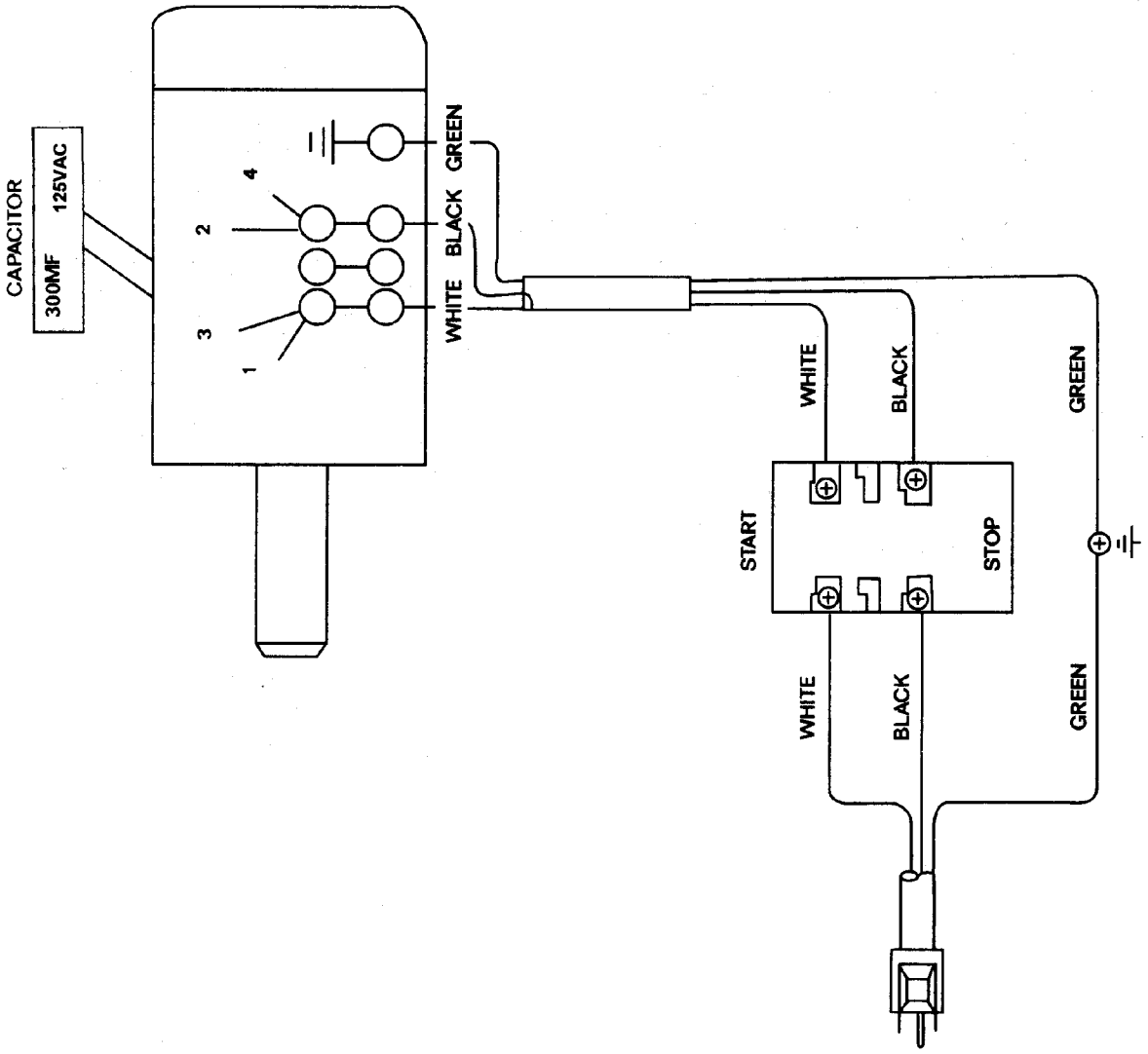
| Index No. | Part No. | Description | Size | Qty |
|---|---|---|---|---|
| 1 | 150602W | Top Plate | | 1 |
| 2 | 150603W | Stand Leg | | 4 |
| 3 | 150604W | Support Plate-long | | 2 |
| 4 | 150605W | Support Plate-short | | 2 |
| 5 | 150606W | Support Plate-upper | | 1 |
| 6 | 150607W | Pulley Cover | | 1 |
| 7 | 150608W | Inner Pulley Cover | | 1 |
| 8 | 990804 | Self Tapping Screw | M4x8 | 5 |
| 9 | 150609W | Motor | | 1 |
| 10 | 600013 | Motor Pulley | | 1 |
| 11 | VB-A39 | V-belt | | 1 |
| 12 | TS-1523011 | Socket Set Screw | M6x6 | 1 |
| 13 | PG-M02 | JET Plaque | | 1 |
| 14 | TS-1533031 | Flat Head Screw | M5X10 | 2 |
| 15 | TS-1490061 | Hex Cap Screw* | M8x35 | 4 |
| 16 | 991516 | Carriage Bolt* | M8x16 | 40 |
| 17 | TS-15550051 | Washer* | M8 | 52 |
| 18 | TS-155108 | Lock Washer* | M8 | 48 |
| 19 | TS-1540061 | Hex Nut* | M8 | 48 |
| 20 | TS-1533042 | Phillips Pan Head Machine Screw* | M5x12 | 3 |
| 21 | TS-1550031 | Flat Washer* | M5 | 6 |
| 22 | TS-1540041 | Hex Nut* | M5 | 3 |
| 23 | 150623 | Rubber Mount* | | 4 |
| 24 | 150624 | Support Plate | | 1 |
| 25 | 995004A | Motor Cord | | 1 |
| 26 | 150627 | Pad | | 1 |
| 27 | JWBS14OS-208 | Rubber Foot (set of 4) | | 1 |
| | WBS14OS-HK | Hardware Kit (not shown) | | 1 |

* ..... included in hardware kit

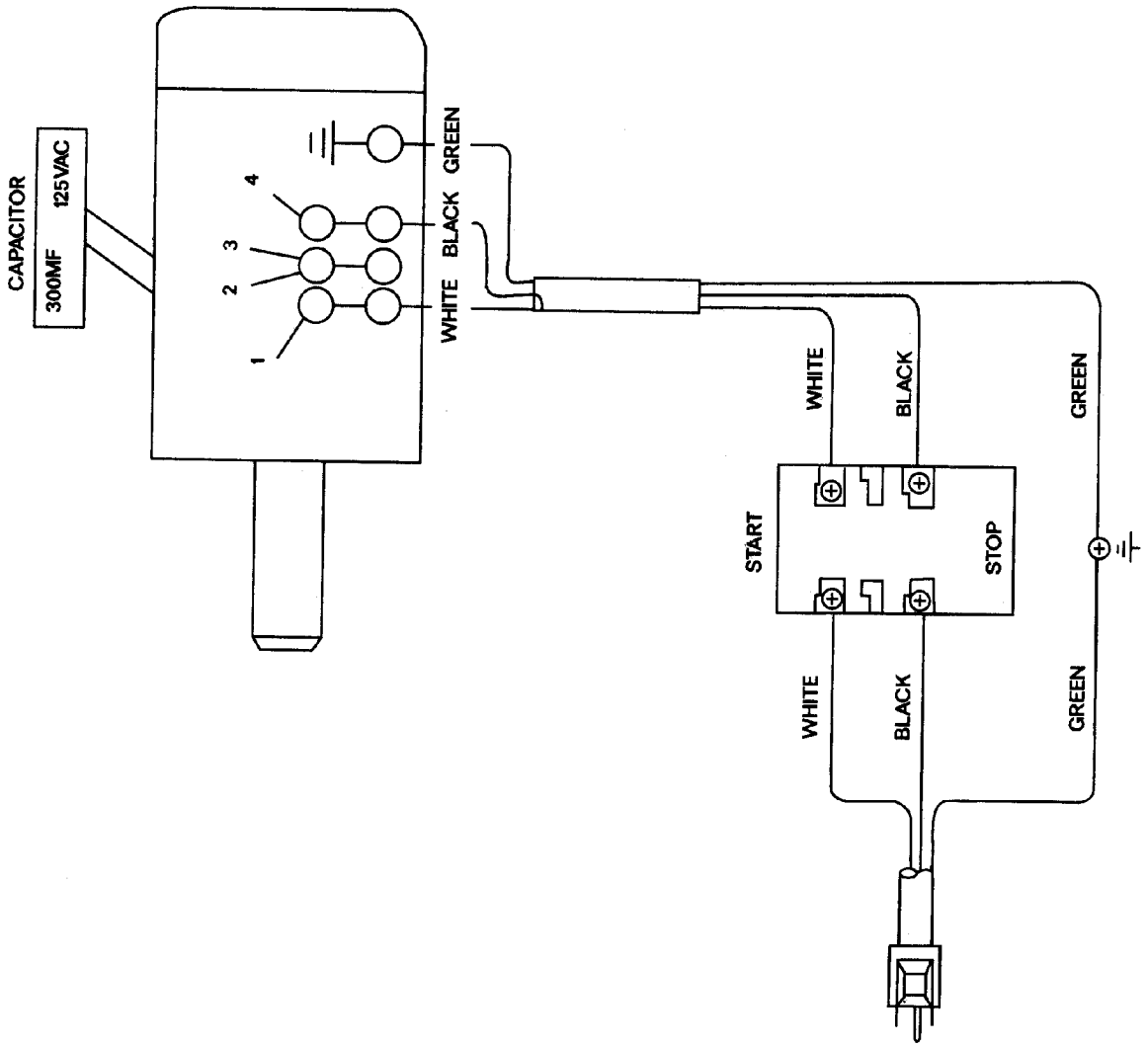
## Open Stand Assembly (JWBS-14OS Band Saw)



# Electrical Connections – 115 volt (JWBS-14CS/OS Band Saw)



# Electrical Connections – 230 volt (JWBS-14CS/OS Band Saw)

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